DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-029805
Date Inspected: 11-Jul-2013

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job Site

CWI Name: William Sherwood and Fred Michels

CWI Present:	☑ Yes	☐ No					
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

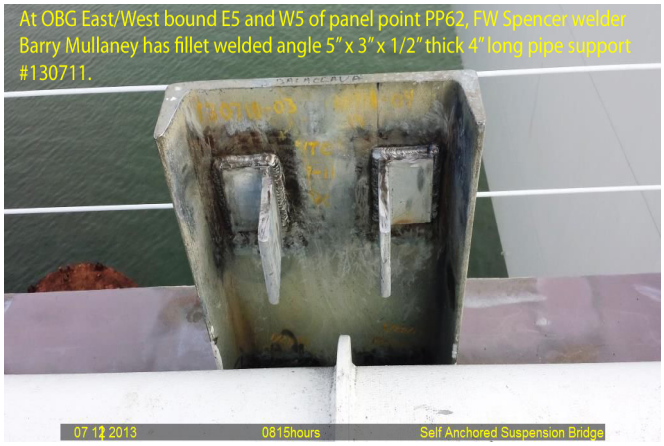
FW Spencer:

At location bikepath E panel point PP77, this QA randomly observed FW Spencer qualified welder Tim Esquivel continuing to perform Complete Joint Penetration (CJP) 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on 2.5” diameter domestic water line field butt joints. The welder was noted welding the root pass with 3/32” diameter E6010 electrode and followed by fill pass to cover pass using 3/32” diameter E7018H4R electrode implementing Caltrans procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propylene gas torch prior welding. During welding, ABF QC Fred Michels was noted monitoring the parameters of the welder. At the end of the FW Spencer shift, CJP welding on three (3) 4” diameter domestic water line field butt joints (elbow/pipe) designated as 54/2. 5/77/BE, 54A/2.5/77/BE and 61/2.5/77/BE were completed.

At locations W5 and E5 panel point PP62, FW Spencer Barry Mullaney was observed perform all position all around fillet welding the angle 5” x 3” x ½” thick (4” long) pipe support #130711-1 to #130711-4. The welder was noted using Shielded Metal Arc Welding with 1/8” E7018H4R electrode implementing Caltrans approved welding procedure specification identified as Fillet Murex. During welding, ABF QC Fred Michels was noted on site monitoring the welder’s welding parameters and workmanship. During the shift, four (4) of the pipe supports

mentioned above was completed. At the end of the shift, the same welder was also noted welding 1" diameter weldolet for the 2.5" diameter domestic water line which was marked 1/DW1/124/NE.

This QA also witnessed ABF personnel continuing to perform caulking on unused bolt holes on angle 203mm x 203mm of top anchorage plate at 14E-PP127. The bolt holes were not used due to interference with the vertical stiffener plate. ABF personnel were noted using the Sikaflex caulk. This task is being done to clear punch list item #3654.



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo,Joselito	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer